

Date: Wednesday, 30/07/2008 5:31:35 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT FACING SEAT ASS'Y RH
Job Number :	40824		
Estimate Number :	13314		
P.O. Number :		Part Number :	D412769044
This Issue :	30/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-769-2 REVB
First Issue :	/ /	Project Number :	N/A
Previous Run :	40001	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/08/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>JUL 087 31</u>		
Comment :	Est rev A 08.05-12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3782045	Back Leg Assembly
-----	----------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Back Leg Assembly

batch: B 40873

SB

3.0	D3782041	Front Inboard Leg Assembly
-----	----------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Inboard Leg Assembly

batch: B 40870

SB

4.0	D3782044	Front Outboard Leg Assembly, RH
-----	----------	---------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Outboard Leg Assembly, RH

batch: B 40872

SB

5.0	D3783041	Lateral Brace Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lateral Brace Assembly

batch: B 40874

SB 08/08/20 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:31:35 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D3783043	Longitudinal Brace Assembly
-----	----------	-----------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Longitudinal Brace Assembly
batch: B 40875

SB

7.0	D3783045	Angle Brace Assembly
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Angle Brace Assembly
batch: B 40876

SB

8.0	D3784041	Seat Support Assembly, Center
-----	----------	-------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, Center
batch: B 40877

SB

9.0	D3784043	Seat Support Assembly, LH
-----	----------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, LH
batch: B 40878

SB

10.0	D3784044	Seat Support Assembly, RH
------	----------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, RH
batch: B 40879

SB

11.0	D37662	Front Rail, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Front Rail
batch: B 40864

SB

12.0	D37663	Rear Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rear Rail
batch: B 40740

SB

08/08/20

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D37671	Upper Rail
------	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B40711

SB 08/08/20 (1)

14.0	D37921	Seat Belt Eye Bolt
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: B40209

SB

15.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108077

SB

16.0	AN45 13A	EYE BOLT
------	----------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M107938

SB

17.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M108471

SB

18.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

SB

19.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M108558

(or NAS1149D0363J) batch: _____

SB 08/08/20 (1)

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108161

(or NAS1149D0463J) batch: _____

SB

21.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M108246

(or NAS1149D0568J) batch: _____

SB

22.0

AN52510R24

Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108270

SB

23.0

MS21042L3

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M108764

SB

24.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107499

SB

25.0

MS21042L5

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108471

SB 08/08/20 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 08-08-21

①

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21

28.0

POWDER COATING

POWDER COATING



M 106442



⑫

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15

OVEN TEMPERATURE:

320 °F

FINISH TIME:

10:45

M-1 08/08/21

29.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/08/21

⑩

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guard

batch:

B 40658

FF 08/08/21

①

31.1 D3792-1 seat belt eye bolt

Qty 3

batch: B 40209

SB 08/08/21

③

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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32.0	D37741	Seat Bottom, LH/RH
------	--------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Bottom, LH
batch: B40587

FF 08/08/21

①

33.0	D37743	Seat Back, LH/RH
------	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Bottom, LH
batch: B40588

FF 08/08/21

①

34.0	AN525 10R22	Screw
------	-------------	-------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Screw
batch: M108270 M107936

FF 08/08/21

①

35.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Washer
batch: _____
(or NAS1149D0332J) batch: M105793

FF 08/08/21

①

36.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)
Nut
batch: M108764x13 / M108747x13

FF 08/08/21

①

37.0	AN35A	Bolt
------	-------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
batch: M100180

FF 08-08-21

①

38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- install remaining parts as per dwg D412-769-2

FF 08/08/21

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 40824

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/08/21 (40)

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 40804

AS 08/08/22 (40)

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22 (40)

Job Completion



mf 08-08-22

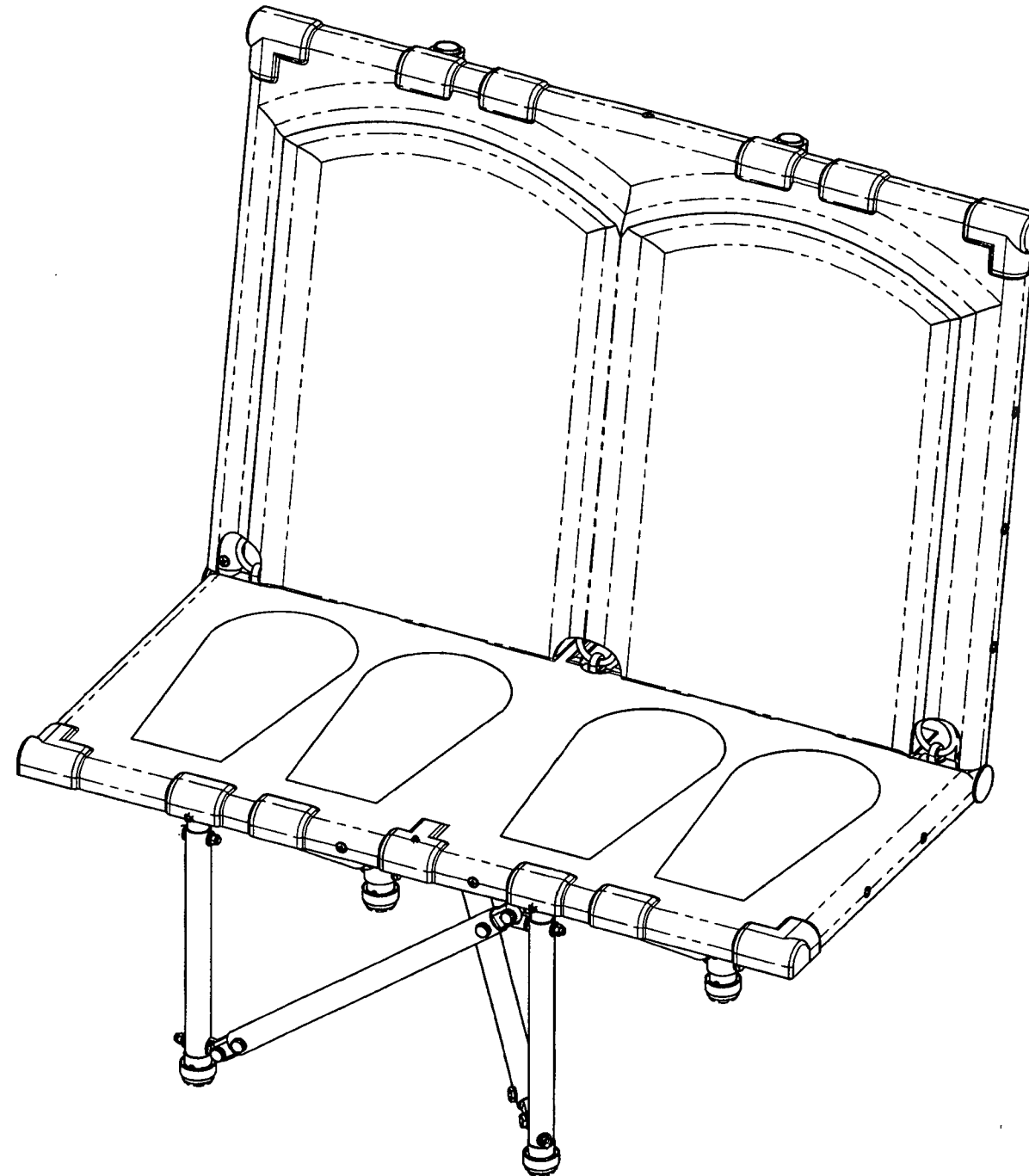
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



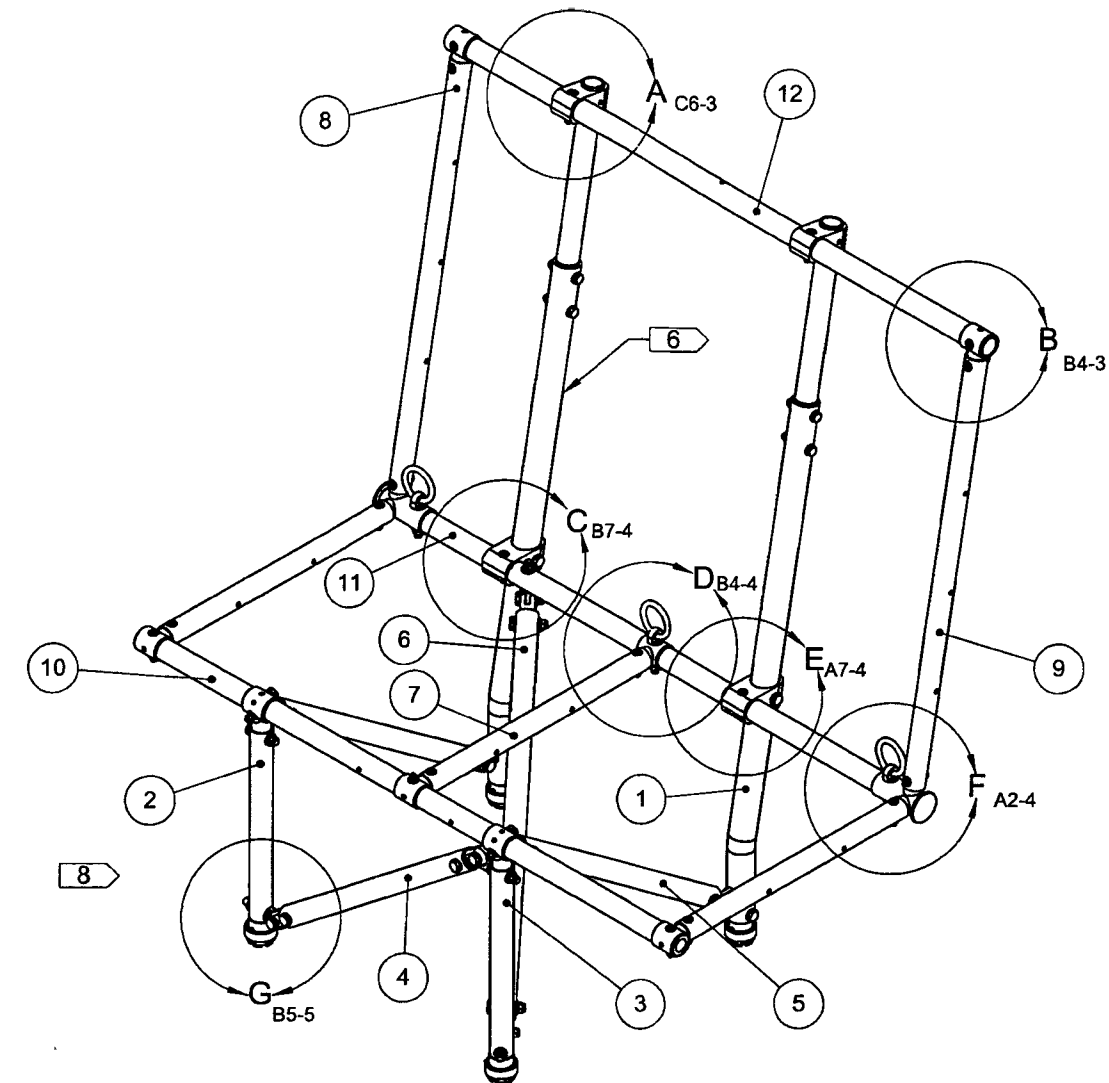
D412-769-044 AFT FACING SEAT, RH

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-2	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASE
08-07-10/MP

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WORK ORDER
NO. **40824**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
 - 7) WEIGHT: 30.0 lbs
 - 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

D412-769-044 AFT FACING SEAT, RH

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08-07-10

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-2	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
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AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3767-1
UPPER RAIL
REF

D3782-045
BACK LEG ASSY
REF

DETAIL A_{D2-2}
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL

D3767-1
UPPER RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3784-044
SEAT SUPPORT ASSY, RH
REF

DETAIL B_{C1-2}
SEAT SUPPORT END ATTACHMENT (TYP)
5 PL

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08-07-10

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NO. 40824

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CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	MM	D412-769-2	SHEET 3 OF 7
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	AFT FACING SEAT ASSY, RH	NTS
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D3782-045
BACK LEG ASSY
REF

AN45-13A EYE BOLT (1)
NAS1149D0568J WASHER (1)
MS21042L5 NUT (1)

D3766-3
REAR RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3766-3
REAR RAIL
REF

D3782-045
BACK LEG ASSY
REF

DETAIL E C2-2
REAR RAIL TO BACK LEG ATTACHMENT

D3784-041
SEAT SUPPORT ASSY, CENTER
REF

D3766-3
REAR RAIL
REF

DETAIL D C1-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (2)
MS21042L5 NUT (1)

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (2)
MS21042L5 NUT (1)

D3775-1
GUARD
REF

D3784-044
SEAT SUPPORT ASSY, RH
REF

D3766-3
REAR RAIL
REF

DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-2	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, RH	NTS
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NO. 40824

8

7

6

5

4

3

2

1

D

D

C

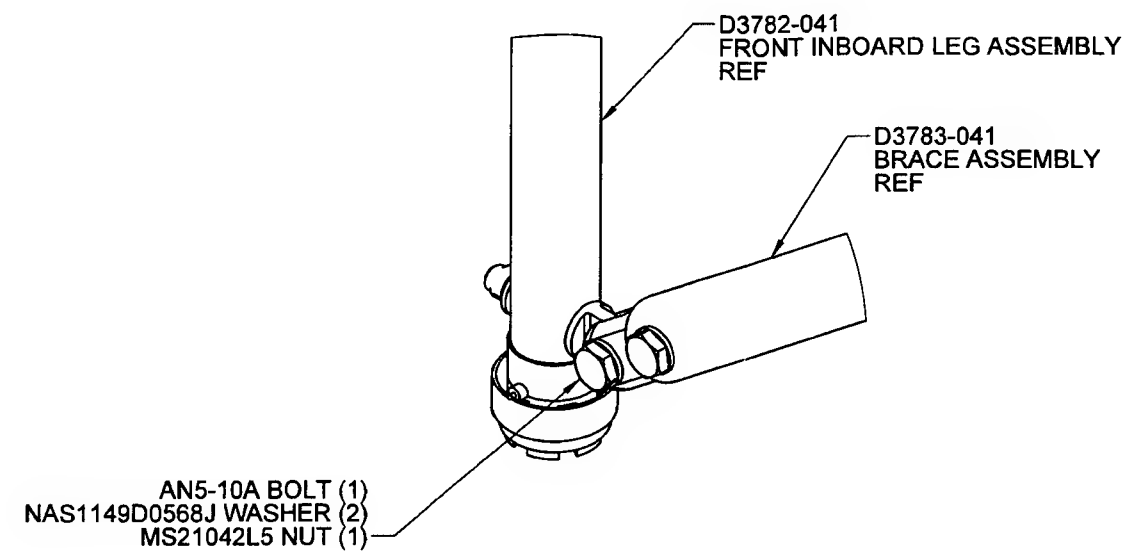
C

B

B

A

A

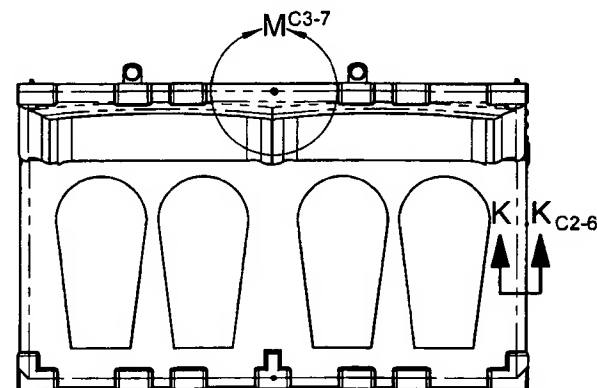


DETAIL G_{B3-2}
BRACE ATTACHMENT
6 PL

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-2	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, RH	NTS
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AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
3 PL PER SIDE

D3784-044
SEAT SUPPORT, RH
REF

1

SECTION H-H

B7-6

AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
2 PL PER SIDE

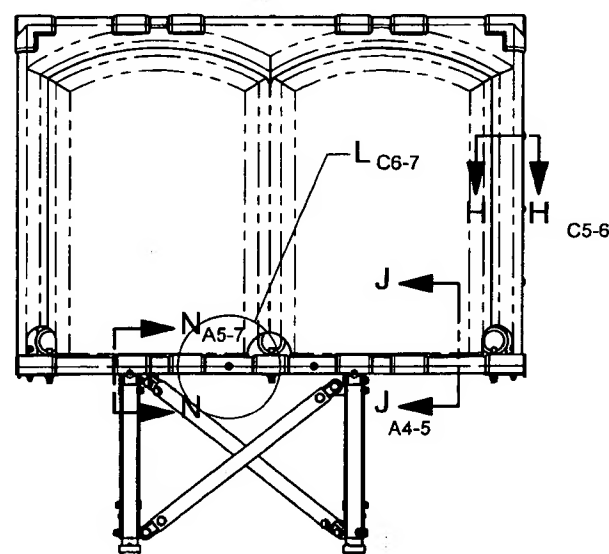
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D3774-1
SEAT BOTTOM
REF

D3784-044
SEAT SUPPORT, RH
REF

SECTION K-K

D7-6



D3766-2
FRONT RAIL
REF

SECTION J-J

B7-6

D3774-3
SEAT BACK
REF

D3774-1
SEAT BOTTOM
REF

D3766-3
REAR RAIL
REF

3

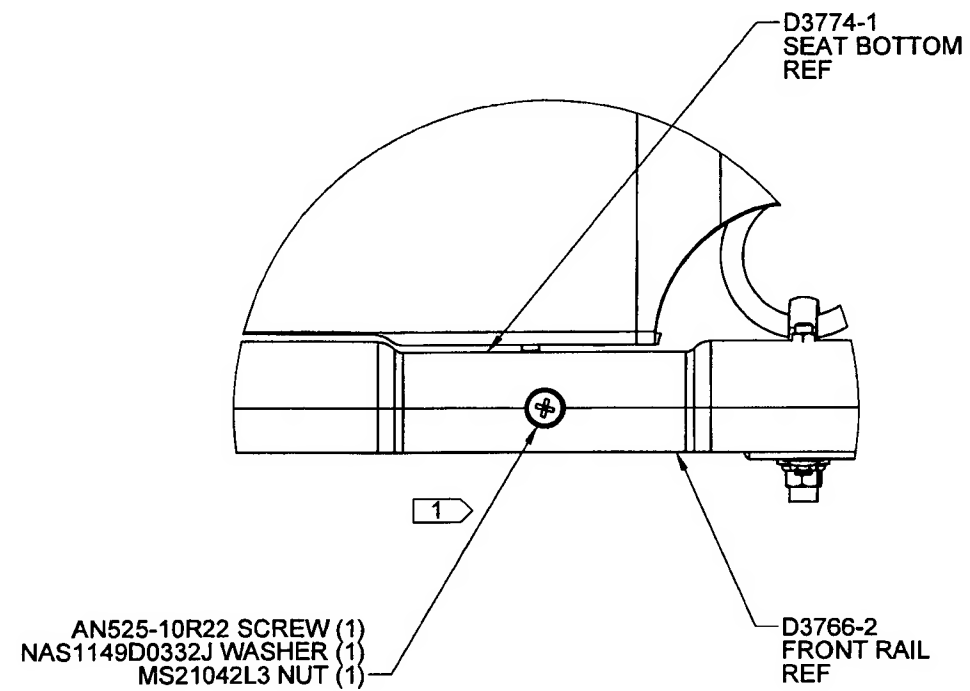
AN3-5A BOLT (1)
NAS1149D0363J WASHER (2)
MS21042L3 NUT (1)
6 PL

RELEASED
68-07-10

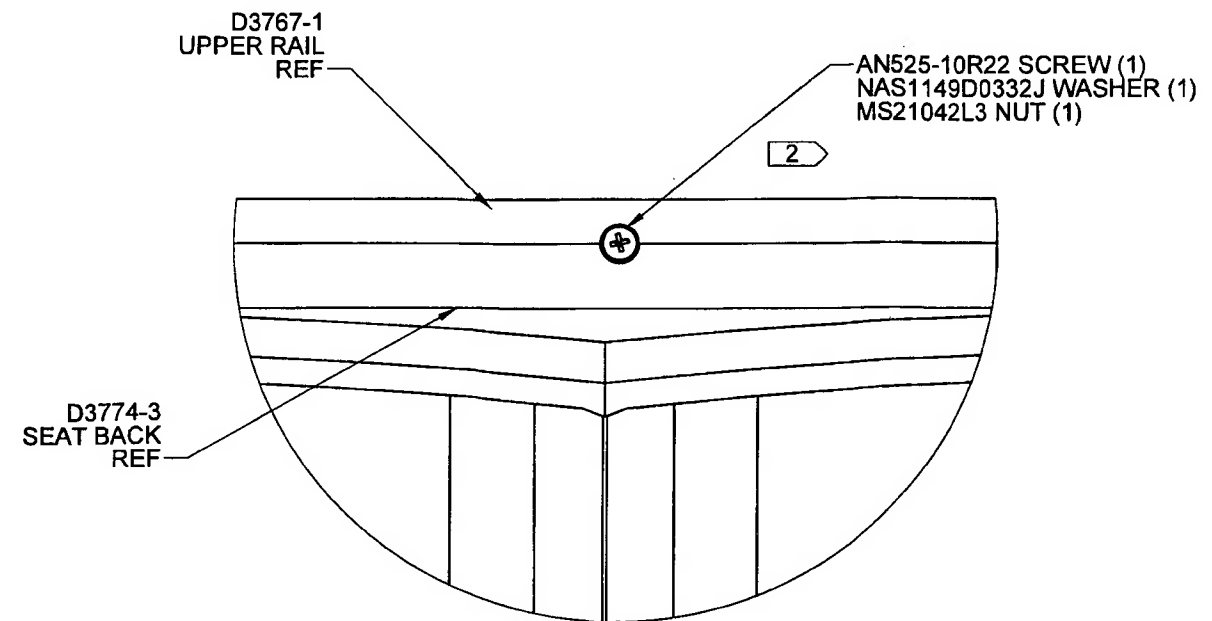
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WORK ORDER
NO. 40829

- NOTES:**
- 1) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
 - 2) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
 - 3) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

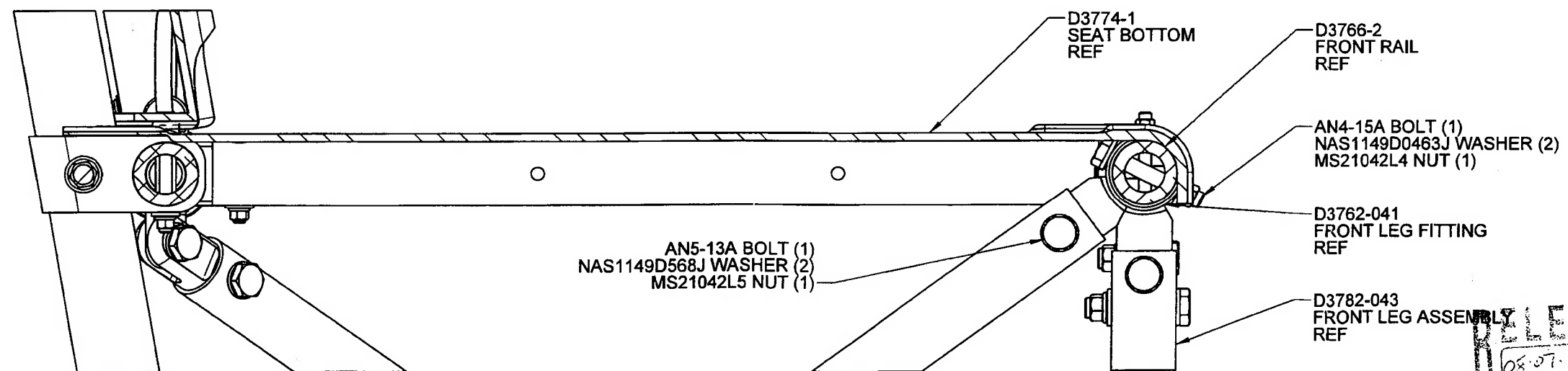
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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-2	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, RH	NTS
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DETAIL L B7-6
SEAT BOTTOM ATTACH - FRONT DETAIL



DETAIL M D7-6
SEAT BACK ATTACH - TOP DETAIL



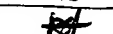


SECTION N-N B7-6
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT

NOTES:

- 1) TRANSFER DRILL HOLES $\phi 0.201$ FROM FRONT RAIL (D3766-2) TO SEAT BOTTOM (D3774-1) - 2 PL
- 2) TRANSFER DRILL HOLES $\phi 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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MFG. APPR.		D412-769-2	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
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